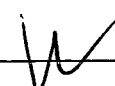


Date: Monday, 14/01/2008 8:30:34 AM
User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : FITTING
Job Number : 36713	
Estimate Number : 11091	
P.O. Number :	Part Number : D30201
This Issue : 14/01/2008 S.O. No. :	Drawing Number : D3020 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : MACHINED PARTS	Drawing Revision : A
Previous Run :	Material :
Written By : 	Due Date : 21/01/2008 Qty: 42 Um: Each
Checked & Approved By :	
Comment : Est. B 03.05.06 Reformat; Made on Cobra KJ/RF	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
----------------	------------------------------	----------------------

1.0	M1018R1250	1018 1/4 ROUND BAR
-----	------------	--------------------



Comment: Qty.: 0.0923 f(s)/Unit Total : 1.8459 f(s)
1018 1/4 ROUND BAR
Material: AISI 1018/1020 Steel Bar, Ø1.25"
(M1018-R1.250)
Batch: M15925

H.A. 08/01/16

42

2.0	HARDINGE	HARDINGE CNC LATHE SMALL
-----	----------	--------------------------



Comment: HARDINGE CNC LATHE SMALL
Turn blank as per Folio FA255 and Dwg D3020

H.A. 08/01/16

42

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

H.A. 08/01/16

PHD 42

4.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
-----	-------------	-------------------------------



Comment: SMALL & MEDIUM FAB RESOURCE 1
Deburr

SF 08/01/17

5.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

SF 08/01/17

40

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3020-1 PAR #: HA Fault Category: Prod / Machine ^{parts} NCR: Yes No DQA: D Date: 08/01/28
 QA: N/C Closed: HA Date: 08/01/28

NCR: <u>36713</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>08/01/16</u>	<u>2.0</u>	<u>6 parts to scrap</u> <u>R.C. Program error, after</u> <u>threading, the boring bar</u> <u>removed the threads.</u>	<u>HA</u> <u>08/01/28</u>	<u>Erreurs multiples</u> <u>dans le programme</u> <u>ex: threading, boring bar</u> <u>Qty (6) B&M 15925 scrap.</u> <u>replace Qty (6) M M15925</u>	<u>Y.A</u> <u>08/01/16</u>	<u>08/01/21</u>	<u>08/01/21</u>	<u>08/01/21</u>

NOTE: Date & initial all entries

Date: Monday, 14/01/2008 8:30:34 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FITTING

Job Number: 36713

Part Number: D30201

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Pat Duval



Comment: PACKAGING RESOURCE #1

Identify and bag with light oil (Vactra oil #2), then Stock

Location: PA+

Ref 4/22 (40)

7.0

QC21

FINAL INSPECTION/W/O RELEASE



08.01.22

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



u 08-11-22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

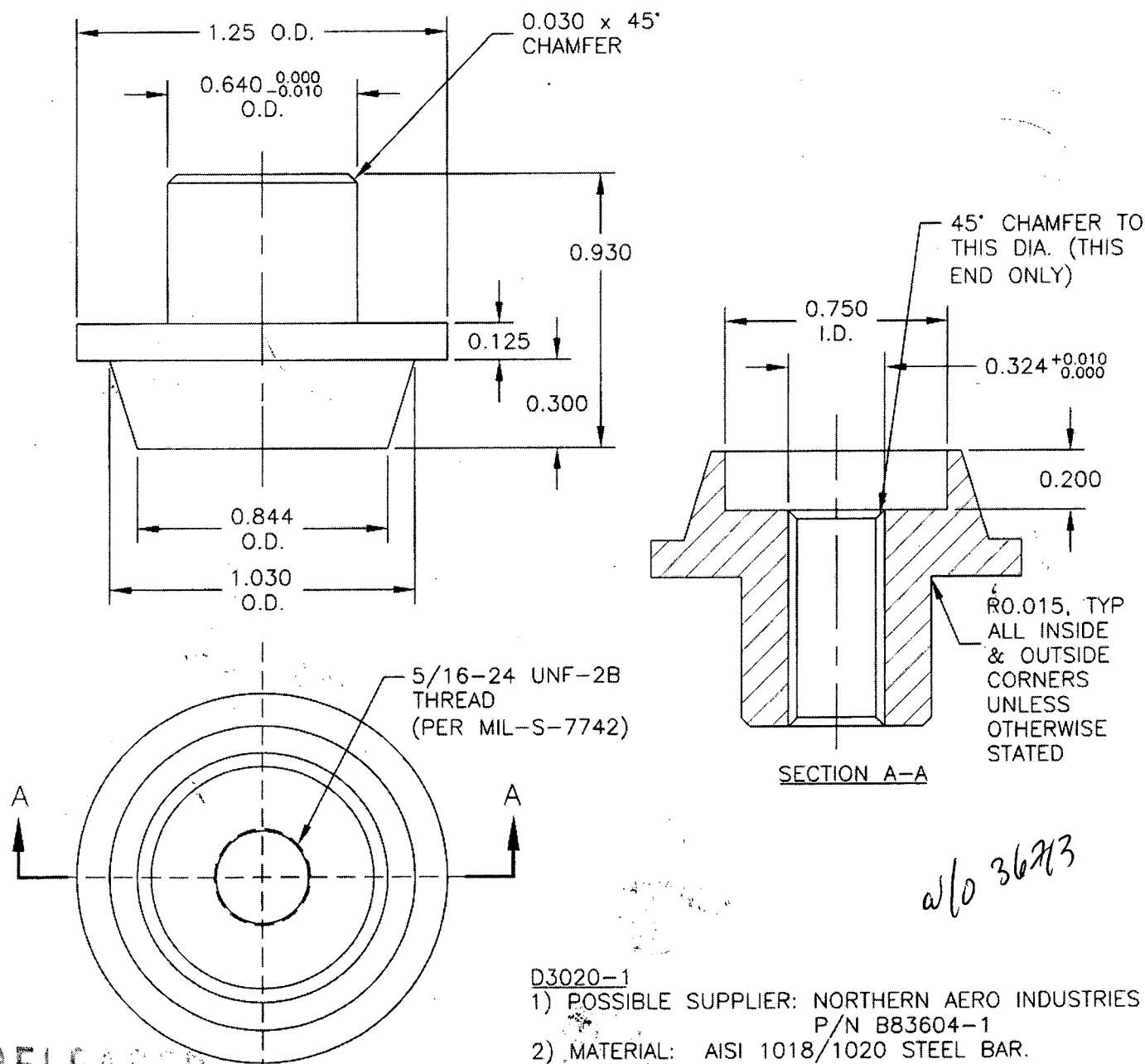
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN UP	DRAWN BY UP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3020	REV. A SHEET 1 OF 1
DATE 01.05.18		TITLE FITTING	SCALE 2:1
A	01.05.18	NEW ISSUE	

SPECIFICATION CONTROL DRAWING



w/o 36713

D3020-1

- 1) POSSIBLE SUPPLIER: NORTHERN AERO INDUSTRIES
P/N B83604-1
- 2) MATERIAL: AISI 1018/1020 STEEL BAR.
- 3) ALL DIMENSIONS ARE IN INCHES.
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

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